



Dart Aerospace Ltd.
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D3916-041
Job Sheet 190514



Part No: D3916-041

Job Qty: 10 ea

Part Name: Rib Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/11/19

Job Tracking No:

Due Date: 2/22/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP RevA: New issue DD verified by:EC IPP Rev:B as per dwg revA 10.03.15 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	2/22/19	2/22/19	0.00	0.00	Start Up Large Fab-5		JH
100	Large Fab	10 pcs	2/22/19	2/22/19	0.00	4.90	Large Fab 8		JH
105	QC	10 pcs	2/22/19	2/22/19	0.00	0.00	QC5		MAR 29 2019
107	Large Fab	10 pcs	2/22/19	2/22/19	0.00	0.00	Large Fab 1		JH
110	QC	10 pcs	2/22/19	2/22/19	0.00	0.00	QC5		JH
120	QC	10 pcs	2/22/19	2/22/19	0.00	0.00	QC10		JH
130	Packaging	10 pcs	2/22/19	2/22/19	0.00	0.00	Packaging3 Large Fab		JH
140	QC21-SA	10 Ea	2/22/19	2/22/19	0.00	0.00	QC21		APR 03 2019

Part Op 100 - 1- Cut tube 50" 2- Bend tube with manuel pipe bender as per DT9567 *** Make line at 9.00" and use jig for other Descriptions: lines, and ensure seam in place on side of tube when bending*** 3- Trim access tube material to finish size as per dwg D3916 4- Drill and chamfer holes as per dwg D3916-1 using DT9605
107 - 1- weld bushing as per dwg D3916 2- grind welds flush
130 - LOCATION: WA004-5

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3759-1	Bushing	70 pcs (7 ea)	90-Start up Operation	30x 5161155 38x 5160918
M304TS0.750W.049	304 Sq Tube .75X.75X.049W	41.6600 ft (4.166 ea)	90-Start up Operation	2x 5155 739 8x 5160 818

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3759-1	70	161	0
	M304TS0.750W.049	42	524	0



Container No: S167251



Part: D3916-041

Job No: 190514

Serial No/Batch: S167251

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					